

BLUE

Dart Aerospace Ltd.

Date: Wednesday, 4/25/2007 2:36:39 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 32057		
Estimate Number	: 10855		
P.O. Number	: <i>N/A</i>	Part Number	: D206628021 <i>DL</i>
This Issue	: 4/25/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31976	Drawing Revision	: N/A
		Material	: <i>N/A</i>
		Due Date	: 5/4/2007
Written By	: <i>[Signature]</i>	Qty:	1 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: D as per ECN 766 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

*CZ* *KS 07.0127* ①

2.0	32057A	206L/407 STEP ASSY, LH
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Comment: Sub-Component SUB-COMPONENT

D2724-041 B *32057A*
*[Signature]* *7/5/18*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D27317	Mounting Lug
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2731-7	Mounting Lug	

*to be shipped at 2 later date* *X*

5.0	D2856400	Abrasion Strip
-----	----------	----------------



Comment: Qty.: 1.1708 f(s)/Unit Total: 1.1708 f(s)

Pick:

Qty	Part #	Description	Batch
2	D2856-400 6.9"	Abrasion Strip	

*B30822X* *7/5/12SQ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32057

Part Number: D206628021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3394043	LUG ASS'Y
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3394-043	LUG ASS,Y	

*X to be shipped at a later date*

7.0	AN412A	Bolt
-----	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-12A	Bolt	M103962 X

8.0	AN413A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-13A	Bolt	M103943 X

9.0	AN415A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN4-15A	Bolt	M104072 X

10.0	AN960JD416	Washer
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	AN960JD416	Washer	M102929 X

11.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS21042L4	Nut (or MS21042-4)	M103914 X

*M/S 1/2 S29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:39 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 32057

Part Number: D206628021

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CL 7/05/18 ① PC 7/5/18 ①

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location:

PPP Rev: E

CL 7/05/18 ①

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 7/18/18 ①

Job Completion



✓ 7/6/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DEL FLEET BLUE spray

Dart Aerospace Ltd.

Date: Wednesday, 4/25/2007 2:36:46 PM  
User: Kim Johnston

D206628-021

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, LH
Job Number	: 32057A		
Estimate Number	: 11702		
P.O. Number	: <i>N/A</i>	Part Number	: D2724041
This Issue	: 4/25/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2724 REV C
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31976A	Drawing Revision	: C
		Type	: LARGE FAB ASSY
		Material	: <i>N/A</i>
Written By	:	Due Date	: 5/4/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
-----	-----------	-----------



Comment: Qty.:	1.0000 Each(s)/Unit	Total :	1.0000 Each(s)
Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>330199</i>

Check Material for any Dents or Defects

*P.E. 07-04-26 1*

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding

*P.E. 07-04-26 1*  
*P.E. 07-04-26 1*

3.0	D2734	206 Step Endplate
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Comment: Qty.:	2.0000 Each(s)/Unit	Total :	2.0000 Each(s)
206 Step Endplate			
Pick:			

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>329340</i>

*P.E. 07-04-26 1*

4.0	D34581	PLATE
-----	--------	-------



Comment: Qty.:	2.0000 Each(s)/Unit	Total :	2.0000 Each(s)
Pick:			

Qty	Part Number	Description	Batch
2	D3458-1	Plate	<i>329354</i>

*P.E. 07-04-26 1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 4/25/2007 2:36:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32057A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

331074

*PE. 07.04.26 1*

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch: M102756  
M103317

Grind end cap welds flush

*PE. 07.04.27 1*  
*PE. 07.04.27 1*  
*FF 07.04.30 1*

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 07-05-01 (1)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/05/03 @*

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.H. 07/05/07*

*(2)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FF 07-05-08 1*

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

*PE. 07.05.09 1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:46 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32057A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig  
DT  
A/R AL ROD Batch: M102756

Grind per dwg D2724

*Handwritten:* P.E. 07.05.09 /  
P.E. 07.05.09 /

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*Handwritten:* 07/05/09 @

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

*Handwritten:* prime

*Handwritten:* FR 07/05/11 @

14.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

SPRAY PAINT DELFLEET BLUE  
AND CLEAR

*Handwritten:* } 25 07-05-15 ml 020816

*Handwritten:* @

15.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

*Handwritten:* 07-05-17 @

*Handwritten:* (P70) **POSITIVE RECALL**

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

*Handwritten:* m103707

*Handwritten:* FR 07/05/17 @

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 07-05-18 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

*Handwritten:* 32057

*Handwritten:* 1

**POSITIVE RECALL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0705-17	15.0	Awaiting signature for NCR reprint. Do not pass step 18.0		0705-17	1	 0705-17	 0705-17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0705-16	15.0	Primer is visible through the paint.	 051042	Scuff repair per Q51005. Apply even coats of blue clear, ensure full coverage.	 0705/16	 0705/17	 051042	 0705-16

NOTE: Date & initial all entries

Date: Wednesday, 4/25/2007 2:36:46 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 32057A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①  
D 07/05/18

Job Completion



U 5745.18

POSITIVE RECALL

EFFECTIVE

07/05/17

AUTH

U

RELEASED

U

DATE

07/05/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

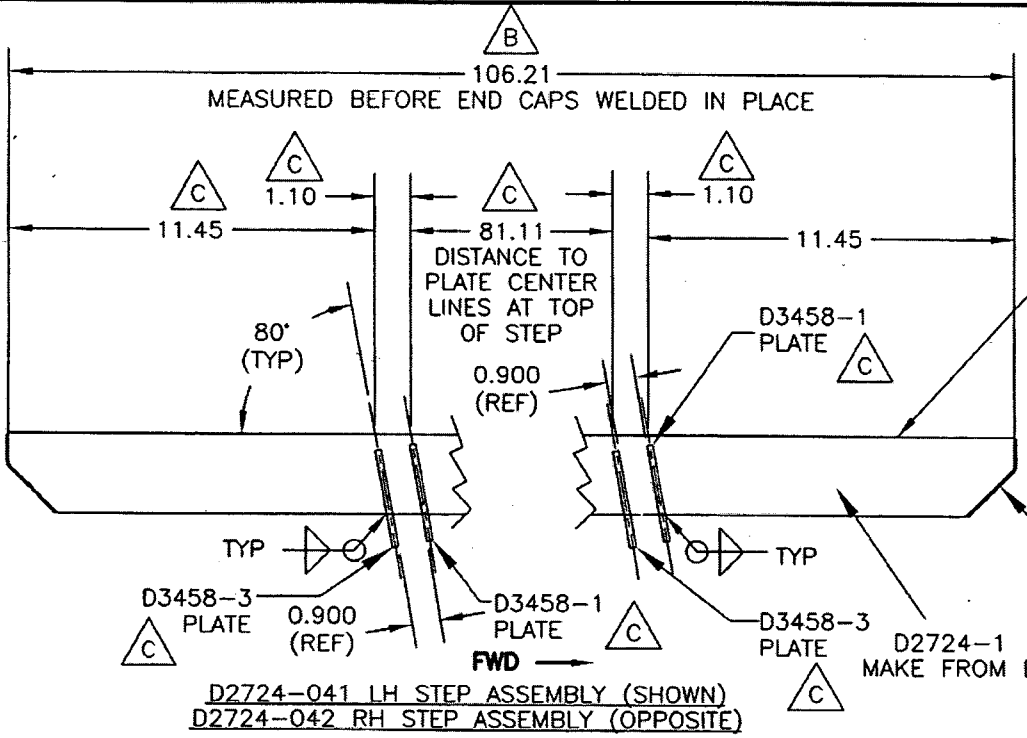
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

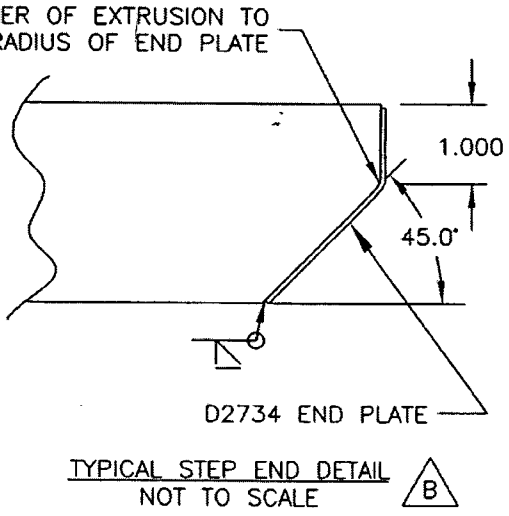
RELEASED  
05.11.14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
KE	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
		D2724	SHEET 1 OF 1	
DATE		TITLE	SCALE	
05.09.19		206L/407 STEP ASSEMBLY	NIS	
A	97.12.04	NEW ISSUE		
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES		
C	05.09.19	RE-DESIGN, ADD D3458-1/-3		



**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



**D2724-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
00-220574

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